Work Ord June-12-13 9:1		2941 		*102	9941*			; ;		Page 1
Item ID: Revision ID:	D3901-3		. 0	Accept	*N900	040,100)* s	etup Start Stop	*N:	S1*
Item Name: Start Date: Required Date Reference:	6/07/13 :: 6/11/13	Start Qty: 24.00 Req'd Qty: 24.00	*? *?	4* 4*	Cust Item I Customer:	D:				S2*
Approvals:	Process Pla	in: MCJ	Date: \\\\ \] Date: \\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\	o−\3 Tooling: SPC (Y/N):		nte:	R	Stop	" V	R1* R2*
Sequence ID/ Work Center I	(D	Operation Description		Set Up/ ** Run Hours	Tool ID	Tool # Plan Code	Accept Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr								
D3901	. Е					· · · · · · · · · · · · · · · · · · ·	w. draft y			· .
100 Cold Saw Hyd Mech	, o	Memo Cut blanks a	at 67.50"	0.00 0.00	J. 131	loclin	.34	<i>p</i> .		
*110 *110* HAAS 1		Memo		0.00 0.00	13/06/	20	36	\$		0A3 08 28
HAAS CNC vertic	ai machine #1		<u> </u>	g D3901,						·

DQA:		Date:						_				TAART
QA Closed:		Date:			WORK ORDER NON	-C(ONFO	RMANCE / UPDA		ork Order up	odate only	AEROSPACE
					DISPOSITION			^	AGAINST DE			· · · · · · · · · · · · · · · · · · ·
Work Orde	er:				DISPOSITION	_				r AINTIVILIYI	- KOCE33	
					Rework			Skid-tube Cr	rosstube		Water Jet	Engineering
Part N	lo				Scrap		1	~—	mall Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is		Therr	~ —	-inishing	Rec/Stor	e/Packaging	Other
NCR N	ło				Suspected Unapproved			Large Fab Co	mposite		Supplier	
Root		-	· -	Desci	ription of work order update		Initial	Action	·	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descriptio	n	Date	Verification	QC Inspector
Design									•			
Doc/Data				·								
Equip/Tooling												
Handling/Pre												
Material												
Operator						ļ						
Offset/Setup		,										
Process					\							
Supplier				·								
Training												
Transport												•
Unapproved									,			
•	 				·	FA	ULT CA	regory				·
Landi	ng Gear				General		-			•		
	Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
	Centre N	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Cracks			L	Broken/Damage/Defect		Hardwa	ire		Part Incorred	t _	Temperature/Cure
	Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unquali	ified	Part Lost/Mi	ssing	Weld
	Cuffs			·	Contamination		-1	tions Incomplete/Unclea	ar	Part Moved		Wrong Stock Pulled
	· Crushing				Countersink		Misalig	ned/off center		Positioned W		===
	Heat Tre	at -			Cut Too Short		Mislabe	eled		Power Loss/S	Surge	Other
	Inspectio	n Strip in	Tube		Drawing		Misread	d				
	Marks/Cl	hatter			Drill Holes		Off-set					
	Turning S	Sequence			Finish		Out of	Calibration				
	Wave/Tv	vist in Tub	oe		Fit/Function		Out of	Sequence				

Work Orde June-12-13 9:1		2941			*102	941*						Page 2
Item ID: Revision ID:	D3901-3		- N		Accept	*N90	\n_	10100)* s	etup Star Stop	I VI	S1*
Item Name:	Bar			40 44						Stop	′ *N	S2*
Start Date: Required Date: Reference:	6/07/13	Start Qty: 24.00 Req'd Qty: 24.00	•	*24* *24*		Cust Ite Custom						
Approvals:	Process Pla	an:	Date:_		Tooling: SPC (Y/N):	.	Date:_ Date:_		R	un Star Stop	, "I V I	R1* R2*
Sequence ID/ Work Center II	D	Operation Description			Set Up/ Run Hours	Tool I	D To	ol# Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*120 *120* QC Quality Control		QC2- Inspect parts off m Memo ***EXTRA			0.00 0.00 JT ON ASSEMBLY***	De	13/06	1/20	<u>36</u>	_\$_		08 08
130 *130* QC Quality Control		QC8- Inspect parts - seco		L WILL BE CU	0.00 0.00 UT ON ASSEMBLY***				36			. <u>J 13-6-24</u>
140 *140* Packaging		Identify as per dwg & Sto	ock Locatio	n: <u>{V<i>40</i></u> 0	0.00				36	13-	06-2	94 MA
Packaging		Memo			0.00							,

DQA:			_ Date:				_						***	DART
QA Closed:			Date:			WORK ORDER NON	-C(ONFO	RMANCE / UP		/ork Order uj	odate only		AEROSPACE
Work Orde	ar.					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
Part N	•					Rework Scrap Use-as-is		1	Skid-tube Machining noforming	Crosstube Small Fab Finishing	_	Water Jet d. Eng. Coor. re/Packaging	- F	Engineering Quality Other
NCR N	No.					Suspected Unapproved		1116111	Large Fab	Composite]	Supplier		
Root					Desc	ription of work order update		Initial	Acti	on	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ct	nief Eng	Descri	iption	Date	Verification		QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved														
							FA	ULT CAT	regory					
Landi	ng (i				General		•			70	. F	٦.	<i>I</i> -
		Bending Centre N Cracks	ot Concer	ntric		Bend BOM/Route Broken/Damage/Defect		Grain Hardwa	Program	-	Outside Dim Over/Under Part Incorre	tolerance	Se	essure/Forced t-up mperature/Cure
		Crimp/Kii Cuffs	nk/Ripple	/Wave		Burrs		4	ion Incomplete/Unditions Incomplete/Un	· —	Part Lost/M Part Moved	issing	\exists_{w_i}	eld rong Stock Pulled
	,	Crushing		٠		Contamination Countersink		Misalig	ned/off center	IICIEAI	Positioned V	_	_	_
	<u> </u>	Heat Trea	at in Strip in	Tube	-	Cut Too Short Drawing	-	Mislabe Misread		L	Power Loss/	ourge [JU	her
		Marks/Cl	· · · · · · · · · · · · · · · · · · ·			Drill Holes		Off-set						
·		Turning S				Finish	匚	4	Calibration					
		Wave/Tw	vist in Tub	e .		Fit/Function	L	Out of S	Sequence					

Work Ord June-12-13 9:1)2941		*102	941*							Page 3
Item ID: Revision ID: Item Name:	D3901-3 Bar			Accept	*N900	040	100)*	•	Start Stop	1 44	S1* S2*
Start Date: Required Date Reference:	6/07/13 e: 6/11/13	Start Qty: 24.00 Req'd Qty: 24.00	*24* *24*		Cust Item I Customer:	D:			_	G		
Approvals:	Process P	lan:	Date:	Tooling:	D:	ate:				Start Stop		R1*
	QC:		Date:	SPC (Y/N):	D:	ate:				- Top	*N	R2*
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Reje Qty		Reject Number	Insp. Stamp
*150 *150*		QC21- Final Inspection -	Work Order Release	0.00	 					3/4	,/25	#

Quality Control

DQA:			Date:	_								•		DART
QA Closed:			Date:			WORK ORDER NON-	-C(ONFO	RMANCE / U		ork Order up	odate only	7 .	AEROSPACE
Work Orde	· ·				w.	DISPOSITION			····	AGAINST DE	PARTMENT	/PROCESS		
Part N	٠ ِ No.					Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engi	Quality Other
Root					Desc	ription of work order update		nitial	Act	tion	Sign &		-	
Cause		Date	Step	Qty		or non-conformance	1	nief Eng		ription	Date	Verification	. 00	C Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved														
							FA	ULT CAT	TEGORY					
Landi		Bending Centre No Cracks Crimp/Kin Cuffs Crushing	nk/Ripple			General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink		Grain Hardwa Inspecti Instruct Misalig	ion Incomplete/Ur ions Incomplete/U ned/off center	<u> </u>	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W	tolerance ct ssing Vrong	Set-up Tempe Weld Wrong	rre/Forced o erature/Cure · g Stock Pulled
	\vdash	Heat Trea		Tube .	\vdash	Cut Too Short Drawing	_	Mislabe Misread		Ĺ.	Power Loss/	surge	Other	
	-	Marks/Ch				Drill Holes		Off-set	4					
		Turning S		-		Finish		1	Calibration					
		Wave/Tw	vist in Tub	e		Fit/Function		Out of S	Sequence					

Page 1

Work Order ID:

102941

Parent Item:

D3901-3

Parent Item Name:

Bar

Start Date: 6/07/13

Required Date: 6/11/13

Start Qty: 24.00

Required Qty: 24.00

Comments:

IPP RevA: New issue DD verified by:EC

verified by:JLM

IPP RevB: Now on cnc JFS 12/02/13

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased	No			100	f	483.8480	5.573	140.7915	8		
304 BAR .250 x .500									e. <u>2:-</u> .				· vi · v

 Location
 Loc Oty
 Loc Code

 MAT049
 483.848

 123902
 0.992

 2/ →124518
 183.855

 3 → 125367
 23.001

 12 → m125804
 276

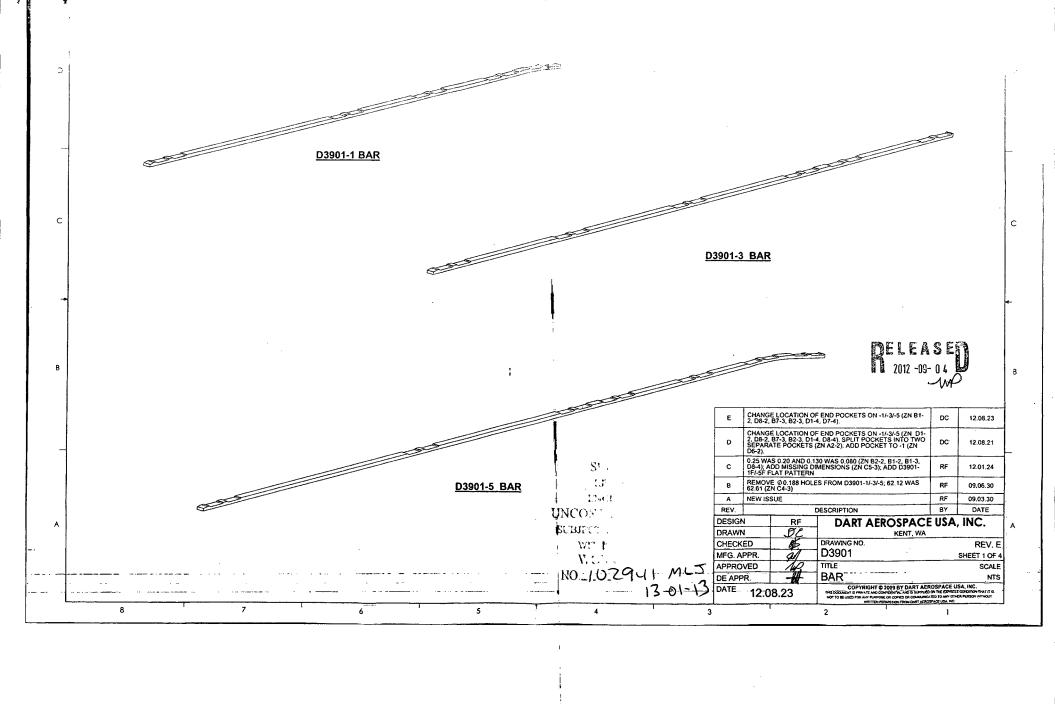
M12 18

30.001 23.001 72

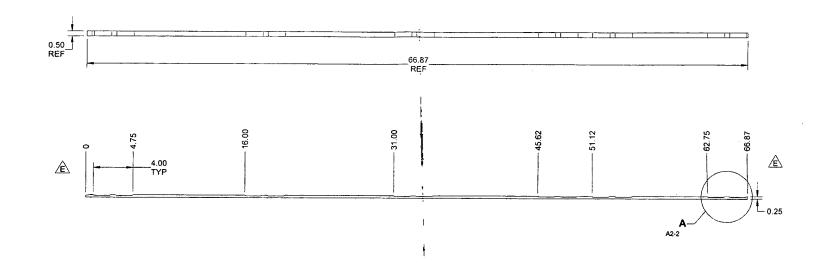
225 on 13/06/14

21-149367

DQA:			Date:										***	``````` `````````````````````````````
						WORK ORDER NON	-C(ONFO	RMANCE / UF					AEROSPACE
QA Closed:			Date:					,		V	Vork Order up	odate only		
Work Orde	or:					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS		
WO IN O I G						Rework	1		Skid-tube	Crosstube	7	Water Jet		Engineering
Part N	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	7	Quality
	•					Use-as-is		Therr	moforming	Finishing		re/Packaging		Other
NCR 1	۷o.					Suspected Unapproved			Large Fab	Composite		Supplier		
Root					Desc	ription of work order update	1	nitial	Acti		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification		QC Inspector
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre							ŀ				•			
Material														
Operator	\vdash													
Offset/Setup	H													
Process	\vdash								,					
Supplier Training														
Transport	-						-	~						
Unapproved	\vdash													
, ,		<u> </u>	<u></u>	L	l	· . · · · · · · · · · · · · · · · · · ·	FA	ULT CA	TEGORY		<u> </u>	1		
Landi	ng (Gear				General				·				
		Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pr	essure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Se	et-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ct [Te	emperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/Mi	issing	w	/eld
		Cuffs				Contamination .		Instruc	tions Incomplete/U	Jnclear	Part Moved		w	rong Stock Pulled
	Ŀ	Crushing				Countersink		4	gned/off center		Positioned V	_		
		Heat Trea				Cut Too Short		Mislabe		L	Power Loss/	Surge	0	ther
	_	Inspectio	•	Tube		Drawing		Misrea						
	L	Marks/Ch				Drill Holes	_	Off-set						
		Turning S				Finish		4	Calibration					
1		Wave/Tw	ist in Tub	e		Fit/Function		Out of:	Sequence					



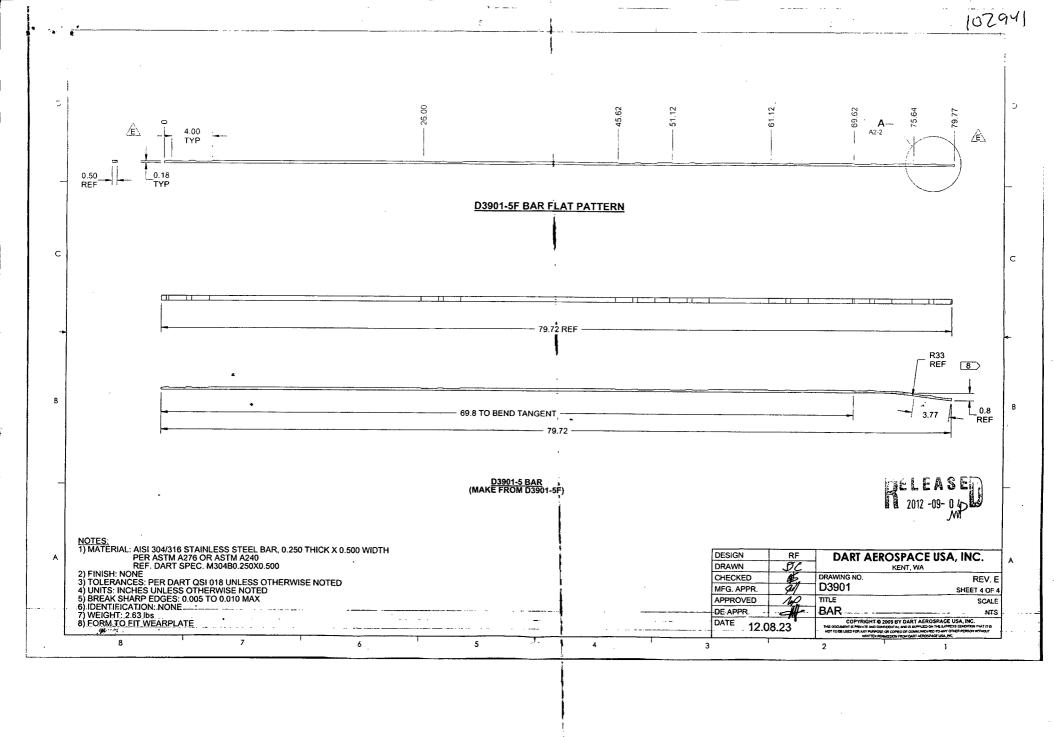
DATE 12:08.23 3



D3901-3 BAR

DESIGN	RF	DART AEROSPAC	E USA, INC.
DRAWN	DC	KENT, WA	\
CHECKED	85.	DRAWING NO.	REV. E
MFG. APPR.	91	D3901	SHEET 3 OF 4
APPROVED	149	TITLE	SCALE
DE APPR.		BAR	NTS
DATE 12.0	08.23	COPYRIGHT © 2009 BY DART AL THIS DOCUMENT IS PROVITE AND CONFEDENTIAL-HING IS SUPPL HOT TO BE USED FOR ANY PURPOSE OR COPED OR COMMAN	ED ON THE EXPRESS CONDITION THAT IT IS

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 THICK X 0.500 WIDTH PER ASTM A276 OR ASTM A240 REF. DART SPEC. M304B0.250X0.500 REF. DART SPEC. M304B0.250X0.500
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK: SHARP EDGES: 0:005 TO 0.010 MAX
6) IDENT#FICATION: NONE
7) WEIGHT: 2.21 lbs



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DART AEROSPACE LTD	Work Order:	102941
Description: BAR	Part Number:	D3901-3
Inspection Dwg: \(\)340\\ Rev: \(\)		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

D	T	T		T	I	T
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.18	+/030	0.175	✓		Ven	69-01
0.50	4/030	0.495	√		11	
1.45	+1030	1.760	V		t l	4(
0.75	4/-030	0.750	✓		(1	1(
0.50	+1-030	0.505	~		Į l	11
4.00	1030	4.000	✓		Į l	d)
4.75	+ 030	4.755	~		10	11
16.00	+030	16.00	V		Tape	6A-12
31.00	4/-030	31.00	~		11	5)
45.62	1-030	45.62	~		10	11
51.12	+1030	51.12	<u> </u>		11	1>
62.75	4 030	62.75	~		11	N)
46.87	·					
						·

Measured by:	۵.۵	OAS	Audited by:	١. ١	Preliminary Approval:	
Date:	13/06/2	0 0 5 9-89	Date:	13-6-24	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

\$ 10.04.15